

**Work Order ID 60691**

Monday, July 19, 2010 12:47:51 PM

Page 1



Item ID: D205-634-041

Revision ID:

Item Name: Replacement Skidtube

Start Date: 7/19/2010 Start Qty: 1.00

Required Date: 8/5/2010 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 10-7-19 Tooling:

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100



DC

DOCUMENT CONTROL

Memo

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

110



BENDING MACHINE - SKIDTUBES

Memo

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No DQA: \_\_\_\_\_ Date: 1008-05  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 60691		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.07.22 J10		AFT BEND IS 1.188" INSTEAD OF 1.4"	GP 10.07.22 QSI 042	Acceptable	DP 10-7-22	S	GP 10.07.22 QSI 042	S 10.07.22

NOTE: Date & initial all entries

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Item ID: D205-634-041

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Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 7/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120

Operation  
Description

Skidtubes

Skidtubes

130



QC

Quality Control

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Stamp

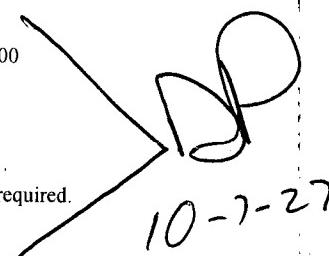
Memo

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.



QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1 Q BE 10/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

140



Skidtubes

Skidtubes

Operation  
DescriptionSet Up/  
Run Hours  
0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004  
A/R□□□ Aluminum Rod

M114242

BE 10/07/28

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R□□□ Aluminum Rod

M114242

BE 10/07/28

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.  
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

DP 10-7-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



QC

Quality Control

Operation  
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

S (07/28)

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S (07/29)

(70)

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

=&gt; M. 10 (07/20)

1

Q

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

180



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

*M 141801*
Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:
*8:10  
200  
8:40*

0.00

*D Bal*
*10-7-29*

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

*= M 10/07/29*

0.00

*1 q*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

200



HandFinish

Hand Finishing

Operation  
Description

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Memo

0.00

=) 40

10/08/03

X1 0

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R   Sikaflex-291  11/15/10  
Sikaflex expire date: 11/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R   Sikaflex-291  11/15/10  
Sikaflex expire date: 11/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4  
Batch: 1116028

W/O:		WORK ORDER CHANGES					
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Item ID: D205-634-041

Accept



Setup

Start



Stop



Revision ID:

Item Name: Replacement Skidtube

Start Date: 7/19/2010 Start Qty: 1.00



Required Date: 8/5/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

210



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

S. Johnson

(40)

0.00

Memo  
Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: 93

PPP Rev: I

10/08/05 SF

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/05 JJ

MF

10-08-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Work Order ID: 60691



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 7/19/2010

Start Qty: 1.00

Required Date: 8/5/2010

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2580-1 		Manufactured	No			110	Each	6.0000	1	1			

205 Skidtube bent detail

Location	Loc Qty	Loc Code
LG	4	
57028	1	
59297	1	
60379	2	
ST046	2	
59913	2	

D2576-3



Step (machining detail)

Manufactured No

140 Each 90.0000 1 1



10-7-22

Location	Loc Qty	Loc Code
LG	90	
46661	42	
52215	48	

D2579



Crossbolt Spacer

Manufactured No

140 Each 313.0000 20 20



BE 10/07/28

Location	Loc Qty	Loc Code
LG	313	
57052	5	
57348	4	
58433	14	
59113	290	

20

BE 10/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Page 2

Work Order ID: 60691



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

D2855



Manufactured No

200

Each

Start Date: 7/19/2010

Start Qty: 1.00

Required Date: 8/5/2010

Required Qty: 1.00

Cap



## Location

FP6

## Loc Qty

1

## Loc Code

56613

ST026

82

50513

50770

51539

53791

1

28

2

51

1

AN3-5A



Purchased No

200

Each

1,128.000



x1 M1 10/07/29

2

## Location

ST350

## Loc Qty

1128

105057

115016

628

500

1

AN960JD10L



NAS1149D0332J Purchased No

200

Each

3,077.000



x2 M1 10/07/29

2

Washer

## Location

ST348

## Loc Qty

3077

110985

3077

1

## Loc Code



2

x2 10/07/29

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 60691

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

ALS7-1032-130



Insert

Purchased

No

200

Each

Start Date: 7/19/2010

Start Qty: 1.00

950.0000 50 50

Required Date: 8/5/2010

Required Qty: 1.00



AN3C4A



BOLT

Purchased

No

200

Each

A1114723

X50

M10107129

50



AN960C10L



NAS1149C0332  
R

Purchased

No

200

Each

1000

0.0000

50

X50

M10107129

50



washer

D3566-13



Gasket

Manufactured

No

200

Each

A1115000

1

1

1

X50

M10107129

1



Location

FP

53461

FP012

Loc Qty

5

5

31

23

8

Loc Code

X1 M10107129

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Work Order ID: 60691



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

D3566-5



Manufactured

No

200

Each

17.0000

1

1

Start Date: 7/19/2010

Start Qty: 1.00

Required Date: 8/5/2010

Required Qty: 1.00

Gasket

D3566-1



Manufactured

No

200

Each

11.0000

1

2

X1 4U 10/07/28

Gasket

D3564-11



Manufactured

No

200

Each

10.0000

1

X2 4U 10/07/28

Wearshoe

D3564-13



Manufactured

No

200

Each

20.0000

1

X1 4U 10/07/28

Wearshoe

### Location

FP015

59158

### Loc Qty

17

17

Each

### Loc Code

11.0000

1

X1 4U 10/07/28

### Location

FP015

57715  
59126

### Loc Qty

11

2

9

Each

### Loc Code

10.0000

1

X2 4U 10/07/28

### Location

FP019

59941

### Loc Qty

10

10

Each

### Loc Code

20.0000

1

X1 4U 10/07/28

### Location

FP17

57922  
59660

### Loc Qty

20

1

19

### Loc Code

20.0000

1

X1 4U 10/07/28

W/O:		WORK ORDER CHANGES							
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Parent Item Name: Replacement Skidtube

Start Date: 7/19/2010

Required Date: 8/5/2010

D3564-9



Manufactured No

200

Each

13.0000

1

1

Start Qty: 1.00

Required Qty: 1.00

Wearshoe

Location

FP

55334

FP019

59201

Loc Qty

1

1

12

12

Each

Loc Code

y1 M 10107129

1

D3564-5



Manufactured No

200

Each

17.0000

1



Location

FG

34806

FP19

57525

58709

FP-19

59157

Loc Qty

1

1

5

1

4

11

11

Each

Loc Code

x1 M 10107129

16



D2594-3



Manufactured No

200

Each

443.0000

16

O-Ring, 205 Skidtube

Location

FP

55546

58191

59358

Loc Qty

443

19

12

412

Loc Code

x1 M 10107129

W/O:		WORK ORDER CHANGES					
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Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

D2594-1



Plug, 205 Skidtube

Manufactured No

200

Each

451.0000

16

16

Start Date: 7/19/2010

Start Qty: 1.00

Required Date: 8/5/2010

Required Qty: 1.00

### Location

FP

### Loc Qty

183

42807

112

55002

71

FP14

268

58434

79

59110

189

### Loc Code

X16

del wlozler

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>#</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07.06.28 *#*

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WITHOUT NOTICE  
WORK ORDER  
NO. *60691*  
*88 10-70*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT-CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AEIS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

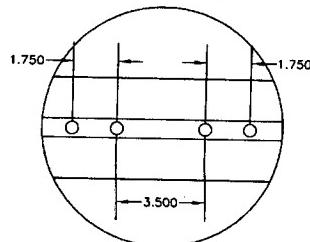
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

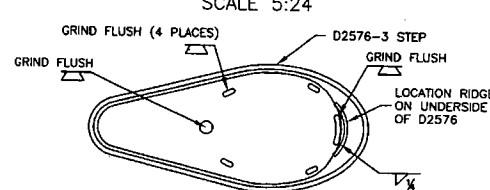
W/o Golgi

DETAIL A  
SCALE 5:24



RELEASED  
07-06-28-A

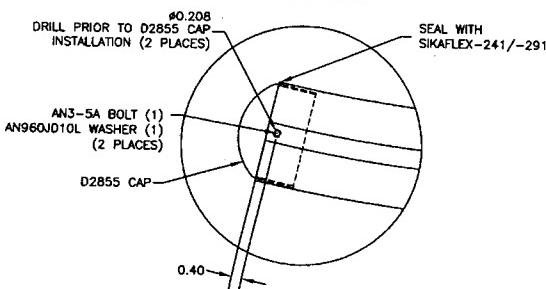
DETAIL B  
SCALE 5:24



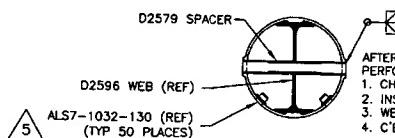
**ELEASED**  
07-06-28-#

07.06.28 - 1

DETAIL C  
SCALE 5:24



**SECTION D-D**  
SCALE 5:24

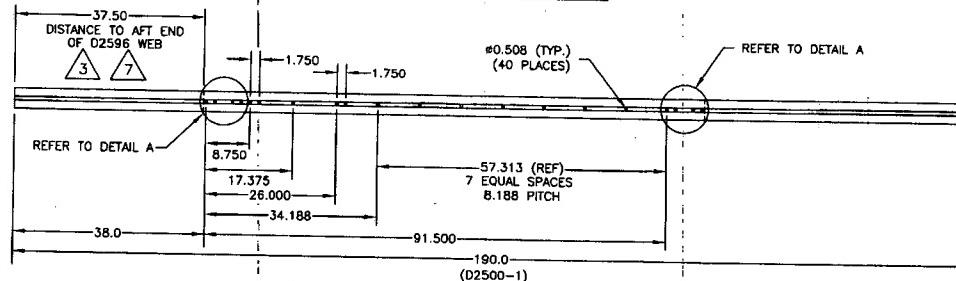


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:  
1. CHAMFER HOLE .050 X 45°  
2. INSERT D2579 SPACER (20 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO #0.417 X 1.00 DEEP

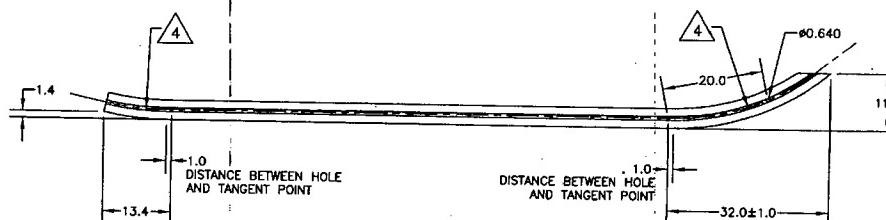
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

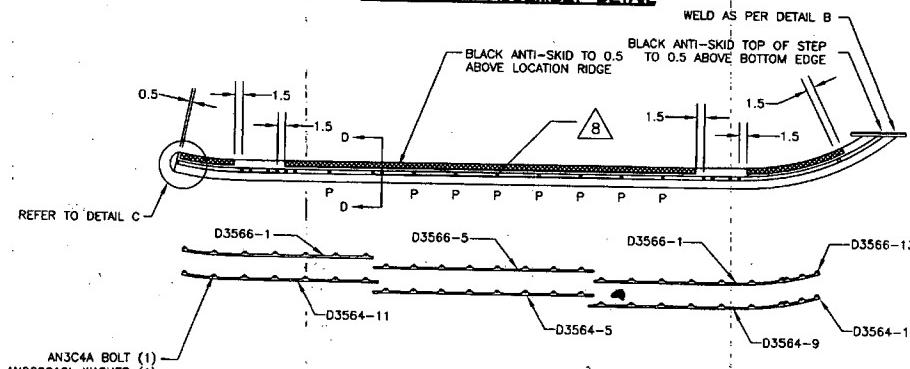
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



AN3C4A BOLT  
AN960C10L WASHER

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CHECKED	APPROVED	DRAWING NO.	REV. D
		D2580	SHEET 2 OF 3
DATE	TITLE		
07.02.27	205 SKIDTUBE ASSEMBLY		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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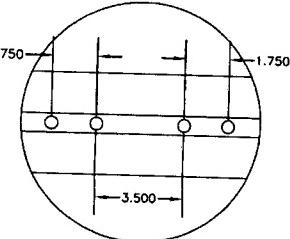
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NOTE: Date & initial all entries

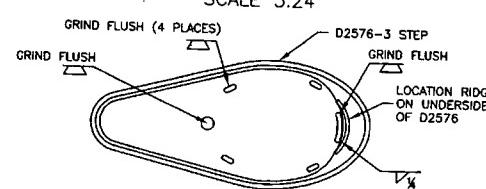
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**DETAIL E**  
SCALE 5:24

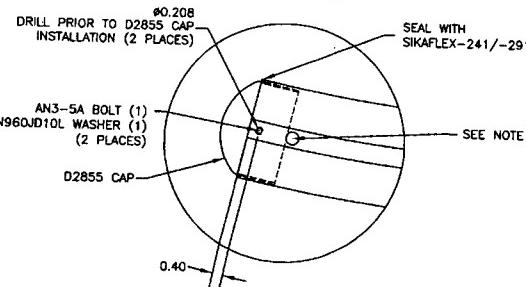


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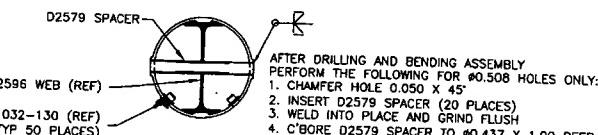
**DETAIL F**  
SCALE 5:24



**DETAIL G**  
SCALE 5:24



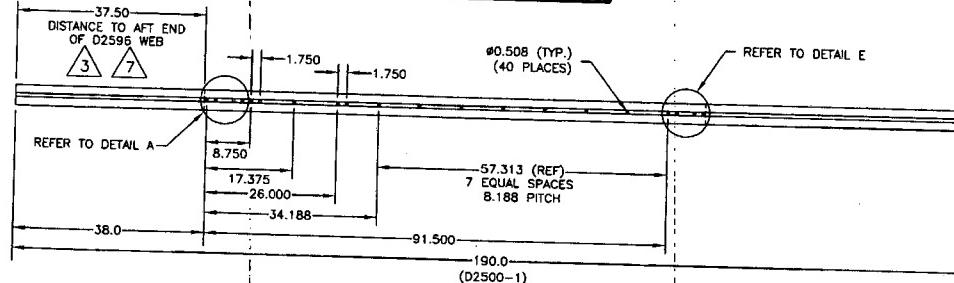
**SECTION H-H**  
SCALE 5:24



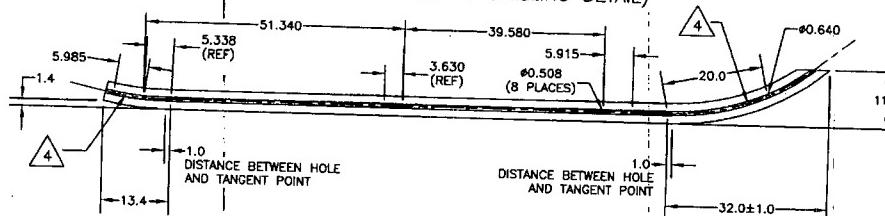
**D2580-045 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

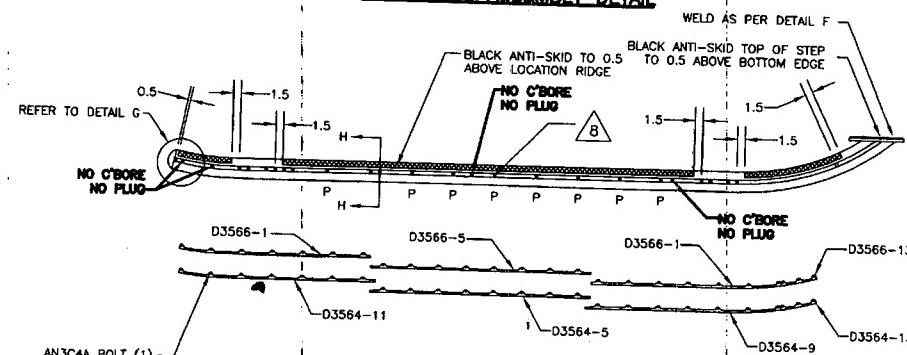
**D2580-1 DRILLING DETAIL**



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



**D2580-045 ASSEMBLY DETAIL**



AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(50 PLACES)

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**DART**

DRAWING NO.

DART AEROSPACE LTD.  
HAWKESBURY, ONTARIO, CANADA

REV. 0

SHEET 3 OF 3

D2580

DATE

07.02.27

TITLE

205 SKIDTUBE ASSEMBLY

SCALE

1:24

W/O:		WORK ORDER CHANGES					Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty		

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NOTE: Date & initial all entries

NO. 232

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Baday Elliott  
Job number: 59P05  
Part number: D205-634-041  
Description: 205 skid tube  
Welding Process: Tig[] Mig[]  
Base materiel: Aluminium  
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[] fail[]

Penetration:

pass[] fail[]

UNACCEPTABLE

Cracks:

pass[] fail[]

Undercut:

pass[] fail[]

Pin holes:

pass[] fail[]

Overlap (cold lap)

pass[] fail[]

Porosity (surface):

pass[] fail[]

Coloration:

pass[] fail[]

Qualifier Pat. Dunn. Date of Test Coupon 10.06.01

Welder Baday Elliott Date of Test Coupon 10.06.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld